

Work Order ID 135832

Friday, August 21, 2015 7:09:27 AM

135832

Page 1

Item ID: D2571

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Fwd, Out

Start Date: 8/21/2015

Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/21/2015

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date: AUG 21 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	F								

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 135832

Double check by: JFC

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect

0.00

0.05

DAS

44

9-89

16/01/07

16/02/24

110

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2571 & D2572

0.00

0.03

4

0

16/02/24

Work Order ID 135832

Friday, August 21, 2015 7:09:27 AM

135832

Page 3

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Fwd, Out
Start Date: 8/21/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/21/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>m 133962</i> Memo START TIME: <i>11:15</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:45</i>	0.00 0.01				<i>H</i>	<i>0</i>	<i>16-02-24</i>	<i>38 34 9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(4)</i>			<i>DAS 38 9-89</i> <i>FEB 24 2016</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <i>57387</i> Memo	0.00 0.00				<i>4</i>			<i>FEB 24 2016</i> <i>DAS 6 9-89</i>

Work Order ID 135832***135832***

Page 4

Friday, August 21, 2015 7:09:27 AM

Item ID: D2571

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd, Out

Start Date: 8/21/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/21/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.01

Quality Control

Handwritten signature and date stamp: **FEB 25 2016**

Picklist Print

Page 1

Friday, August 21, 2015 7:09:31 AM

Work Order ID: 135832

135832

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 8/21/2015

Required Date: 8/21/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	24.0000	1	8			
D6101-007									**	DAS	44	16/01/07	
Saddle Billet										8.00			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT041	16	
131095	1	
133547	15	
MAT044	8	
116083	1	
120494	7	
138056		
136766		

12

4

DART AEROSPACE LTD		Work Order: 135832
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.000	8.003		
F	0.490	0.510		.500	.501	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.505	.505	.503	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.573	.573	.571	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.872	3.871		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.126	.125	.126		
R	0.240	0.260		.251	.250	.250	.251		
S	0.115	0.135		.123	.125	.122	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.240	.240	.239		
W	0.115	0.135		.116	.121	.119	.119		
X	0.308	0.313		.312	.312	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.250	.250	.249		
AE	1.375	1.395		1.390	1.3875	1.3875	1.3875		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.246	.247	.249	.246		
AI	2.000	2.020		2.005	2.003	2.003	2.0035		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject				✓	✓	✓	✓		

Measured by:	44
Date:	16/01/07

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 135832
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.000		
F	0.490	0.510		0.500	0.501	0.504	0.504		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.378	0.370	0.378		
I	0.490	0.510		0.503	0.500	0.499	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.564	0.565	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.125	0.124	0.124	0.124		
R	0.240	0.260		0.251	0.150	0.250	0.250		
S	0.115	0.135		0.122	0.130	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.238	0.238	0.238		
W	0.115	0.135		0.119	0.119	0.117	0.119		
X	0.308	0.313		0.311	0.310	0.310	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.625	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.060	0.060		
AD	0.240	0.260		0.250	0.250	0.248	0.246		
AE	1.375	1.395		1.3885	1.390	1.3905	1.392		
AF	0.115	0.135		0.125	0.130	0.130	0.130		
AG	0.240	0.280		0.255	0.280	0.280	0.280		
AH	0.240	0.260		0.246	0.248	0.248	0.248		
AI	2.000	2.020		2.0035	2.005	2.0045	2.007		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject DAS

Measured by: 44	Audited by: 14
Date: 9-88 16/01/12	Date: 9-88 16/02/24

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 135832
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	14	15	4		
A	0.438	0.443		0.438					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.000					
F	0.490	0.510		0.501					
G	0.257	0.262		0.258					
H	0.375	0.380		0.377					
I	0.490	0.510		0.500					
J	1.174	1.184		1.179					
K	0.558	0.578		0.624					
L	1.174	1.184		1.179					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.874					
P	0.115	0.135		0.130					
Q	0.115	0.135		0.123					
R	0.240	0.260		0.250					
S	0.115	0.135		0.128					
T	0.178	0.198		0.188					
U	2.940	2.980		2.960					
V	0.230	0.250		0.238					
W	0.115	0.135		0.121					
X	0.308	0.313		0.311					
Y	0.760	0.765		0.760					
Z	0.352	0.372		0.361					
AA	0.470	0.530		0.500					
AB	0.615	0.635		0.625					
AC	0.053	0.073		0.063					
AD	0.240	0.260		0.248					
AE	1.375	1.395		1.390	1.388				
AF	0.115	0.135		0.135					
AG	0.240	0.280		0.280					
AH	0.240	0.260		0.245					
AI	2.000	2.020		2.005	2.0013				
AJ	0.023	0.043		0.033					
Accept/Reject				✓				DAS	

Measured by: <i>[Signature]</i>
Date: 16/02/24

Audited by: 9-09
Date: 16/02/24

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	<i>[Signature]</i>

